

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66073

Thursday, February 03, 2011 2:44:58 PM

Page 2

Item ID: D3251-041

Accept

Revision ID:

Item Name: Center Divider

Start Date: 2/3/2011 Start Qty: 4.00

Required Date: 2/17/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00				(4)			
	Memo	0.00							
	Bend as per dwg D3251								
140  QC	QC5- Inspect part completeness to step on W/O	0.00				(24)			
	Memo	0.00							
	Quality Control								
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
	Hand Finishing								

SB 11/03/11

Sullos 1n

4. 0 11/03/11

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Page 3

Item ID: D3251-041

Accept

Revision ID:

Item Name: Center Divider

Start Date: 2/3/2011 Start Qty: 4.00

Required Date: 2/17/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

H B 11-3-14

170

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3251

Edu/03/14 (4)

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/03/14

(4)

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Work Order ID 66073

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Item ID:	D3251-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Center Divider					
Start Date:	2/3/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	2/17/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M112588</i>	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>10:45</i> <i>320°</i> FINISH TIME: <i>11:15</i>								
200 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
210 	Identify as per dwg & Stock Location <i>144</i>	0.00							
Packaging	Memo	0.00							
Packaging									

H BR 11-3-15

4 6 11/03/15

11/3/15

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 66073

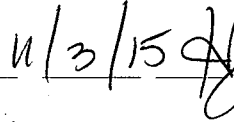
Page 5

Thursday, February 03, 2011 2:44:58 PM

Item ID: D3251-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Center Divider
Start Date: 2/3/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 2/17/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo ..	0.00							

11/3/15 
CL11/03/15

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NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 2:44:50 PM

Page 1

Work Order ID: 66073

Parent Item: D3251-041

Parent Item Name: Center Divider




Start Date: 2/3/2011

Required Date: 2/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3251-1 no longer made in-house
IPP C 08.11.13 in-house EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3248-1 		Manufactured	No			170	Each	0.0000	2	8			
Doubler M2024T3S.063 		Purchased	No			170	sf	55.9270	3.44	14.35789			
2024-T3 .063 sheet												11-3-10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT22		55.927							
				114351		55.927				117018			
MS20470AD4-5 		Purchased	No			100	Each	1,164.000	18	72			
Rivet, Universal Head													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		1164							
				116410		1164							

366195



11/03/14



11-3-10

4



11/03/14

72

1116893 724

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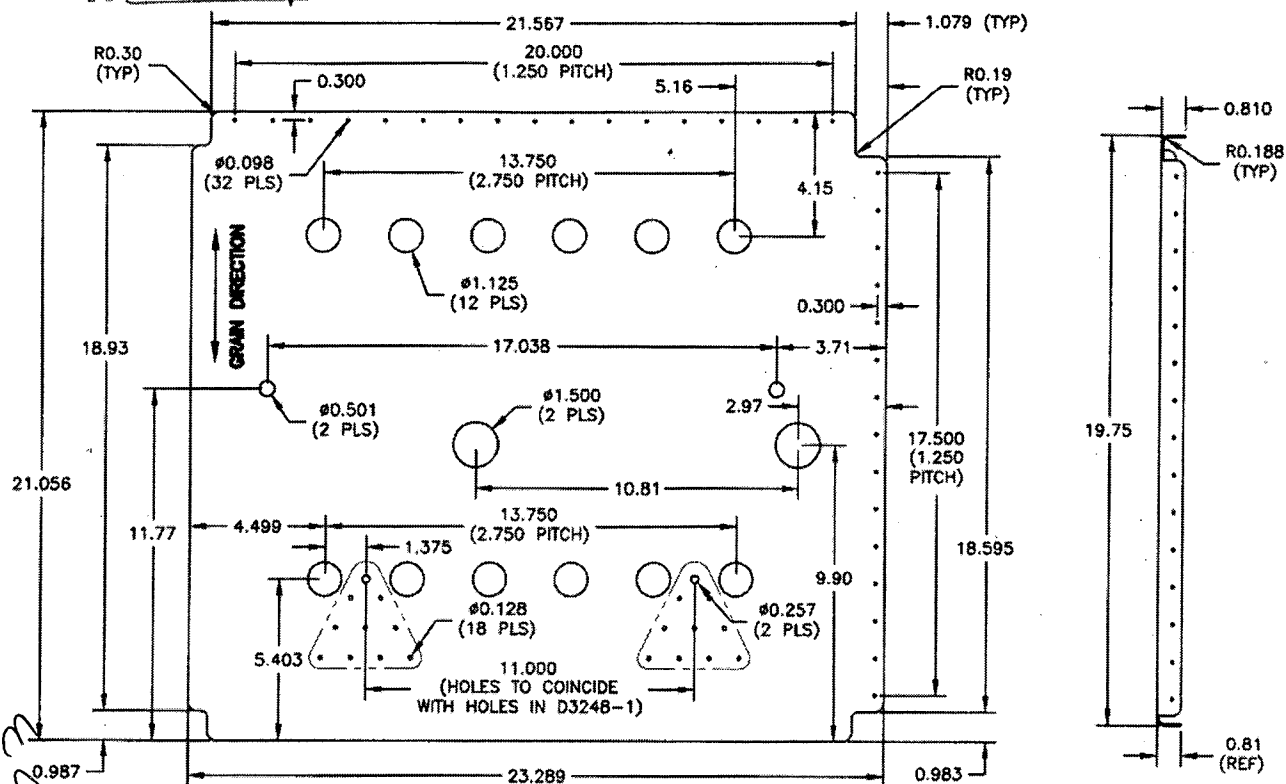
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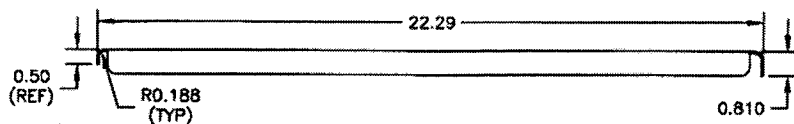
DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3251	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE CENTRE DIVIDER (DUAL BATTERY RACK) 1:5	SCALE
A	04.04.06	NEW ISSUE	

RELEASED
04.05.04 #

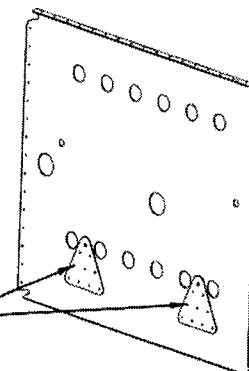


FLAT PATTERN



D3251-1 BEND DETAIL

INSTALL D3248-1
USING MS20470A4-5
RIVETS



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

D3251-041

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DART AEROSPACE LTD		Work Order: 66073
Description: Center Divider (Dual Battery Rack)		Part Number: D3251-1
Inspection Dwg: D3251	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.567	+/-0.010	21.567	X		T H201	
1.250	+/-0.010	1.251	X			
5.16	+/-0.030	5.161	X			
1.079	+/-0.010	1.083	X			
R0.19	+/-0.030	.19	X		R.G.	
4.15	+/-0.030	4.146	X			
2.75	+/-0.030	2.747	X			
0.300	+/-0.010	.301	X			
3.71	+/-0.030	3.705	X			
1.250	+/-0.010	1.253	X			
2.97	+/-0.030	2.97	X			
10.81	+/-0.030	10.807	X			
9.90	+/-0.030	9.903	X			
18.595	+/-0.010	18.595	X			
0.983	+/-0.010	.985	X			
Ø0.257	+0.005/-0.000	.257	X		V	
23.289	+/-0.010	23.289	X			
11.000	+/-0.010	10.998	X			
Ø0.128	+0.005/-0.000	.128	X		V	
5.403	+/-0.010	5.407	X			
0.987	+/-0.010	.987	X			
11.77	+/-0.030	11.764	X			
4.499	+/-0.010	4.499	X			
1.375	+/-0.010	1.371	X			
2.750	+/-0.010	2.748	X			
Ø1.500	+0.005/-0.000	1.500	X			
Ø0.501	+0.005/-0.000	.501	X			
21.056	+/-0.010	21.056	X			
18.93	+/-0.030	18.93	X			
Ø0.125	+0.005/-0.000	.125	X			
Ø0.098	+0.005/-0.000	.099	X		V	
R0.30	+/-0.030	.30	X		R.G.	
0.300	+/-0.010	.303	X		V	
0.063	+/-0.010	.062	X		V	
Grain along 21.056	N/A		X			

Measured by: RB	Audited by: M/M	Prototype Approval: N/A
Date: 11-3-10	Date: 11-03-10	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	[Signature]

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